

Work Order ID 84181

84181

Ship Wednesday

Page 1

Item ID: D412-761-051

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Alternate Armrest

Stop ***NS2***

Start Date: 5/7/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/9/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *12-05-07* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9520	A
IIN D412-761	D

100 *SP* 0.00

100

DOCUMENT CONTROL

DC

Memo 0.00

Document Control

Photocopy bluefile & type labels per PPPD412-761-051/ DSI9520
CHG002

*** CHG001 IF USING D3801-3 REV.A ***

110 Pick Kit 0.00

110

Packaging

Memo 0.00

Packaging

①

12-05-09

IX

SP 12-5-8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84181***84181***

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Monday, May 07, 2012 10:36:50 AM

Item ID: D412-761-051

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Alternate Armrest

Start Date: 5/7/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/9/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00				①			12-05-09
Quality Control									
130		0.00							
130	Packaging								12/5/09
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD412-761-051/ DSI9520								
	Location: _____								
	PPP Rev: <u>B</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							12-05-09
Quality Control									ME

12-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 07, 2012 10:36:49 AM

Page 1

Work Order ID: 84181

Parent Item: D412-761-051

Parent Item Name: Alternate Armrest

Start Date: 5/7/2012

Required Date: 5/9/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.05.18 verf:EC
535 DD VERF:EC

IPP REV:B 12.03.06 AS PER ECN12-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-6 Castellated Nut		Purchased	No			110	Each	9.0000	1	80			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		9							
				110139		9							
AN3-6A Bolt		Purchased	No			110	Each	303.0000	11	80			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		303							
				117441		36							
				120498		17							
				120644		100							
				121060		50							
				121166		100							
AN6-26 Bolt		Purchased	No			110	Each	6.0000	1	80			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST342		6							
				112489		6							
AN960JD10 Washer	NAS1149D0363J	Purchased	No			110	Each	0.0000	11	80			
AN960JD616L Washer		Purchased	No			110	Each	0.0000	1	80			
D3694-041 MOUNTING PLATE		Manufactured	No			110	Each	0.0000	1	80			
D3695-041 Slider Assembly		Manufactured	No			110	Each	1.0000	1	80			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST255		1							
				56890		1							

11 12/13/13 80
1 12/04/18
1 384182
1 12-5-8
1X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 07, 2012 10:36:50 AM

Page 2

Work Order ID: 84181

Parent Item: D412-761-051

Parent Item Name: Alternate Armrest

Start Date: 5/7/2012

Required Date: 5/9/2012

Start Qty: 1.00

Required Qty: 1.00

D4097-041
Armrest Assembly
MS21071L3
ANCHOR NUT

Manufactured No

110 Each 0.0000



B 84183

MS21071L3
ANCHOR NUT

Purchased No

110 Each 88.0000



SP³

Location

Loc Qty

Loc Code

ST302

88

102587

38

114348

50

3x

MS21075L3
Nutplate

Purchased No

110 Each 137.0000



SP⁸

Location

Loc Qty

Loc Code

GA

88

121090

88

ST303

49

120910

49

8x

MS24665-302
Cotter Pin

Purchased No

110 Each 196.0000



M 1174600 SP

Location

Loc Qty

Loc Code

ST309

196

120521

196

1x

NAS1515H6L
WASHER

Purchased No

110 Each 42.0000



SP² 12-5-8

Location

Loc Qty

Loc Code

ST277

42

18918

42

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

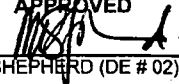
REFERENCE ONLY

PARTS LIST

QTY.	PART NUMBER	DESCRIPTION
X	D412-761-051	ARMREST KIT, LH
1	D3694-041	MOUNTING PLATE ASSEMBLY
1	D3694-1	* KEYWAY
1	D3694-3	* PROTECTIVE PLATE
1	D3694-5	* MOUNTING PLATE
1	AN526C1032R8	* SCREW
5	AN960JD10	* WASHER
4	MS21042L3	* NUT
2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
1	MS24693-C271	* SCREW (OR MS24693-S271)
4	MS24693-C273	* SCREW (OR MS24693-S273)
1	D3695-041	SLIDER ASSEMBLY
1	D3695-1	* SLIDER
1	D3695-3	* STOPPER
1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
4	MS24693-C276	* SCREW (OR MS24693-S276)
1	D4097-041	ARMREST ASSEMBLY
1	D3696-041	* ARM ASSEMBLY
1	D3696-1	** ARM
1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
1	D4098-041	* CUSHION ASSEMBLY
1	D4099-1	* BRACKET
3	MS21042L3	* NUT
5	MS24693-C273	* SCREW
3	MS24693-C277	* SCREW
3	NAS1149D0332J	* WASHER
11	AN3-6A	BOLT
1	AN6-26	BOLT
1	AN310-6	CASTELLATED NUT
11	AN960JD10	WASHER
1	AN960JD616L	WASHER
2	NAS1515H6L	WASHER
1	MS24665-302	COTTER PIN
3	MS21071L3	ANCHORNUT
8	MS21075L3	NUTPLATE

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE
 ** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED
 BY: 
 D. SHEPHERD (DE # 02)
 DATE: 10.05.10
 CERT. NO.: SH09-4
 ISSUE NO.: 2

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9520 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		ALTERNATE ARMREST INSTALL NTS
DATE	10.05.10	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>

Work Order ID 84181

Monday, May 07, 2012 10:36:50 AM

84181

Page 1

Ship Wednesday

Item ID: D412-761-051

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Alternate Armrest

Start Date: 5/7/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/9/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *YMF*

Date: *12-05-07* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI 9520

A

IIN D412-761

D

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPPD412-761-051/ DSI9520
CHG002

*** CHG001 IF USING D3801-3 REV.A *** *B*

110

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

MLJ 12/05/08

*D412-761 > D3696-041 > D3801-3
58895 > 58010
55571 > Rev.A*

IX

*SP
12-5-8*

Work Order ID 55571

January 21, 2010 2:25:09 PM

Page 1

Item ID: D3801-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Hand Retractable Spring Plunger

Start Date: 1/21/10 Start Qty: 20.00

Cust Item ID:

Required Date: 1/27/10 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-1-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3801

Rev A

100

0.00

PURCHASING

Memo

Issue P/O:

Purchase Part Number: PTR-2
Supplier: REID SUPPLY COMPANY

Certificate of conformity is required

0.00

Purchasing

REFERENCE ONLY

110

0.00

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure material certification is attached

0.00

Packaging

Packaging

120

0.00

QC6- Inspect dimensions to drawing

Memo

Ensure Material certification comply to Dwg D3801

0.00

QC

Quality Control

10-1-21
(20)

Re 10/20/28

2/20/28

counters
(20)

Picklist Print

April 21, 2010 12:56:58 PM

Page 1

Work Order ID: 58010

Parent Item: D3696-041

Parent Item Name: Arm Assembly

Comments: IPP Rev:A New Issue 08-05-01 JLM Verified By:EC
IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC IPP
REV:C NOW ON CNC MILL 10-03-17 JLM VERIFIED BY:DD

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M7075T6B1.000X1.000		Purchased	No			100	f	12.0000	6.1231			
7075 T6 BAR 1.00 x1.00												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

12

114415

12

170

Each

52.0000

4.0000



6.1231 DA 10/04/28

D3799-1

Manufactured No



Oilite Bronze Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST088

52

44915

52

170

Each

16.0000

4.0000



4X m-l
10/05/10

D3801-3

Manufactured No



Hand Retractable Spring Plunger

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST088

16

55571

16

4X m-l
10/05/10

REFERENCE ONLY